

54402 Derev

Work Order ID 53767

November 18, 2009 8:02:14 AM



Page 1

Item ID: D3140-09

Accept



Setup Start



Revision ID: F

Stop



Item Name: Doubler Assembly

Start Date: 18/11/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: *09/11/10*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3140	Rev F								

100



Small Fab

0.00

(5x)

Small Fab

Memo

0.00

Assemble as per Dwg D3140

=7 09/12/07

110



QCS- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

=7 09/12/07

(+5)

120



Identify as per dwg & Stock Location: *(5)*

0.00

Packaging

Memo

0.00

Packaging

Leg/14/08(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE:-Date & initial all entries

Work Order ID 53767

November 18, 2009 8:02:14 AM



Page 2

Item ID: D3140-09

Accept



Setup Start



Revision ID: F

Stop



Item Name: Doubler Assembly

Start Date: 18/11/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

09/12/08 AF

MF

09-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 18, 2009 8:02:24 AM

Page 1

Work Order ID: 53767



Parent Item: D3140-09RevF



Parent Item Name: Doubler Assembly

Start Date: 18/11/2009

Required Date: 25/11/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	---------------------	---------------	----------	------------------	---------------	--------------	-----------------	-------------	-----------------------	------------	-------------	--------

D3140-85RevF



Manufactured

No

100

Each

2.0000

5.0000



Angle

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	2	
31215	1	
35188	1	

B 3152667

5X m-L oul/12/03

D3140-89RevF



Manufactured

No

100

Each

0.0000

5.0000



Doubler

MS20426AD3-43



Purchased

No

100

Each

7,861.000 25.0000



RIVET

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	7861	
104374	3861	
110398	4000	

B 52918

5X m-L oul/12/03



25X m-L oul/12/02



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DATE 06.10.06		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

RELEASED
06.11.13 *✓*

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WORK ORDER
NO. *53767*
M 09-11-06

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
			1	X		D3140-09	DOUBLER ASSEMBLY
				1	X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
			1			D3140-71	PAD
			1	1		D3140-73	PAD
			1	1		D3140-75	PAD
			1	1		D3140-77	PAD
			1	1		D3140-79	PAD
				1	1	D3140-85	ANGLE
	1	1				D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
			1			D3140-91	DOUBLER
				1		D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
			1			D3140-105	DOUBLER
				1		D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
					5	MS20426AD3-4	RIVET



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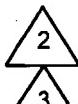
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DATE 06.10.06		TITLE DOOR	SCALE NTS



COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
 MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
 MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
 FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM



FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S



MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-30T1
D3140-303	D3140-303T1



MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECCELL



ALL DIMENSIONS IN INCHES



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION



DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION



RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130



PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND
 ALODINE PER DART QSI 005 4.1

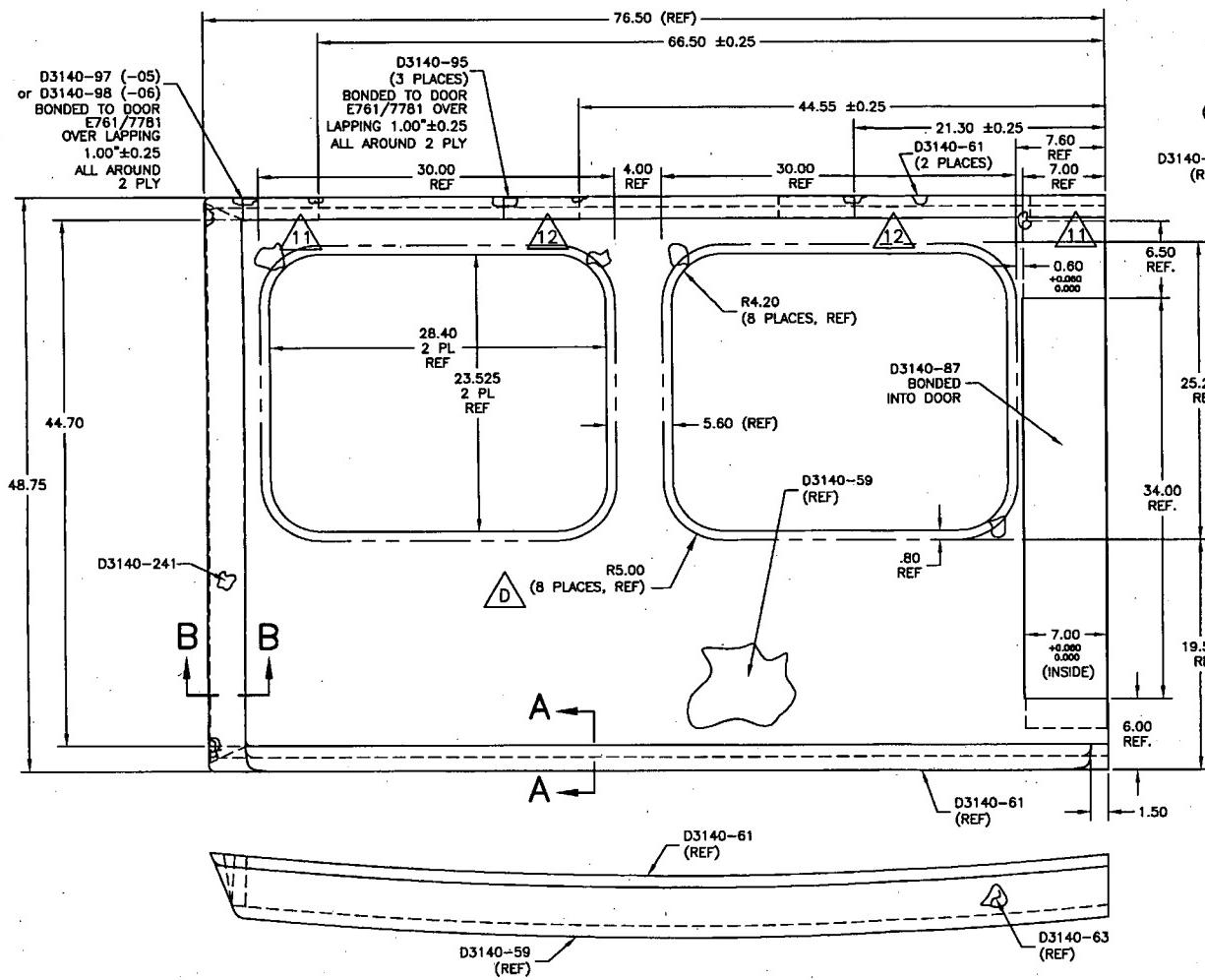
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D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
(WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)



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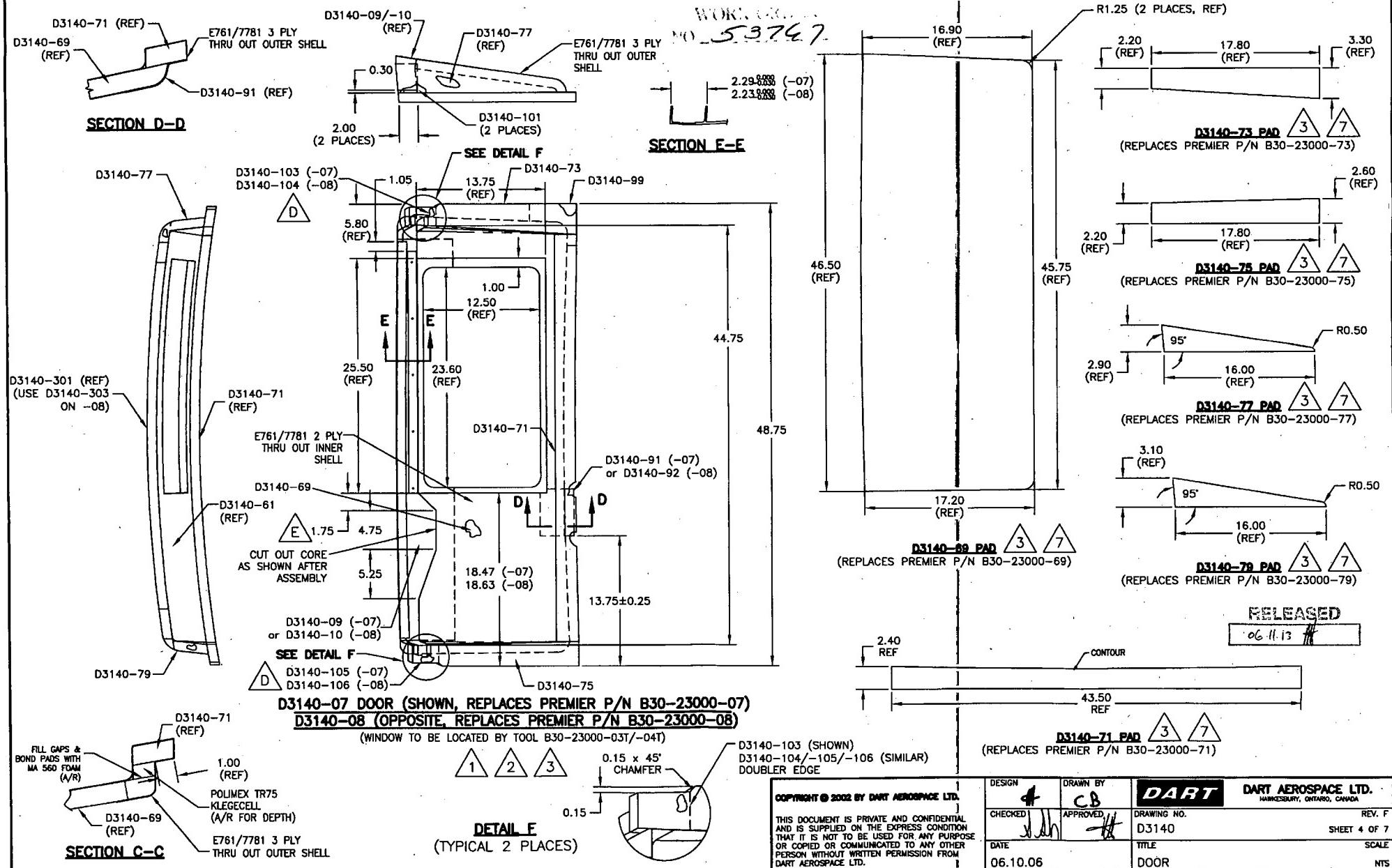
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140	REV. F SHEET 3 OF 7	
DATE 6.10.06	TITLE DOOR		SCALE NTS	

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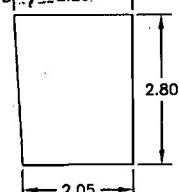
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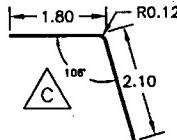
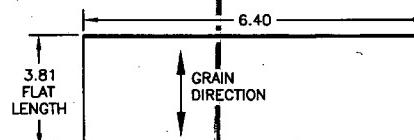
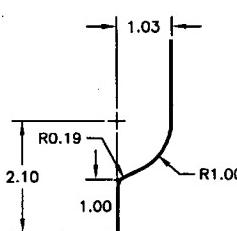
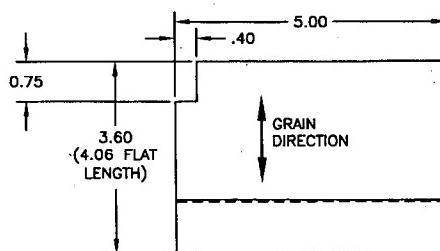
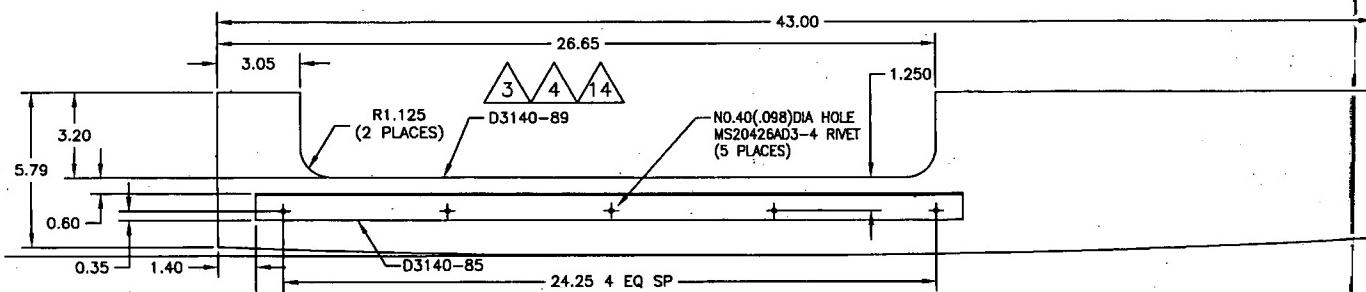
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D3140-101 DOUBLER 4 14
(REPLACES PREMIER P/N B30-23000-101)

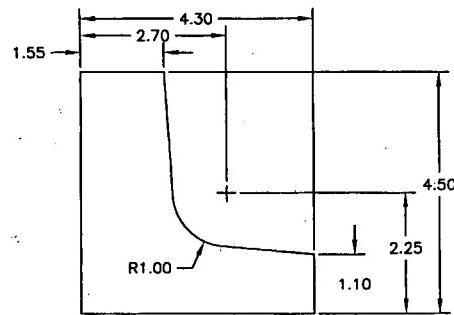


D3140-95 DOUBLER 4 14
(REPLACES PREMIER P/N B30-23000-95)

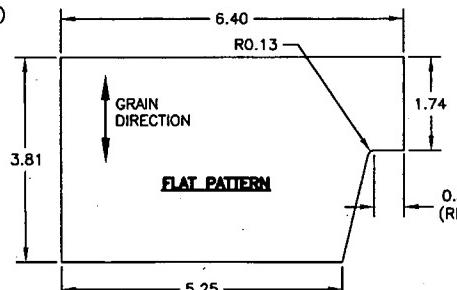
D3140-91F FLAT PATTERN
(USE TO MAKE D3140-91/-92 DOUBLERS)

D3140-92 DOUBLER 4 14 F
(SHOWN, REPLACES PREMIER P/N B30-23000-92)

D3140-91 DOUBLER
(OPPOSITE, REPLACES PREMIER P/N B30-23000-91)



D3140-99 DOUBLER 4 14
(REPLACES PREMIER P/N B30-23000-99)



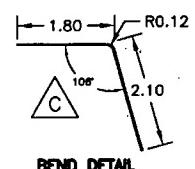
D3140-97 FLAT PATTERN
(USE TO MAKE D3140-97/-98 DOUBLERS)

D3140-97 DOUBLER 4 14
(SHOWN, REPLACES PREMIER P/N B30-23000-97)

D3140-98 DOUBLER
(OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

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1

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4

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J.D.H.

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SHEET 5 OF 7

DATE

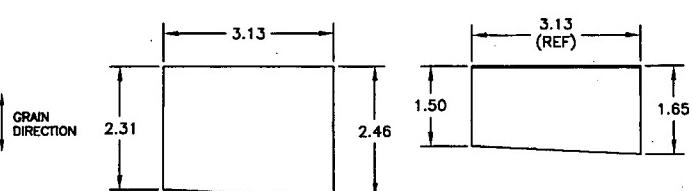
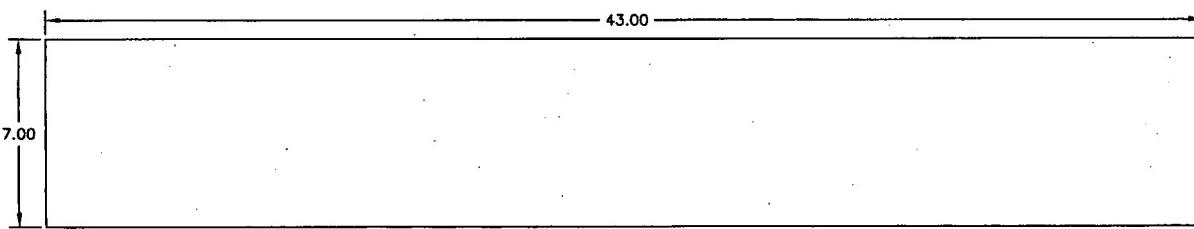
06.10.06

TITLE

DOOR

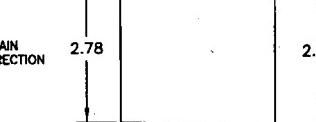
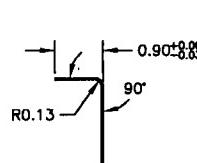
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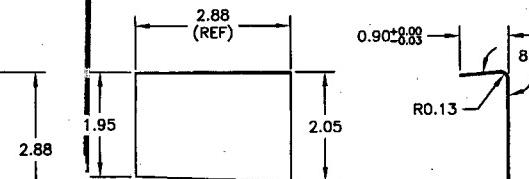


D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)

D3140-105 DOUBLER
D3140-106, OPPOSITE
4 14 D



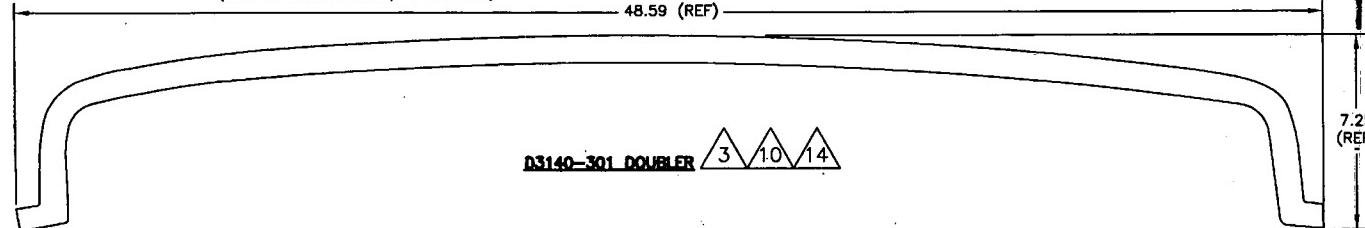
D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)



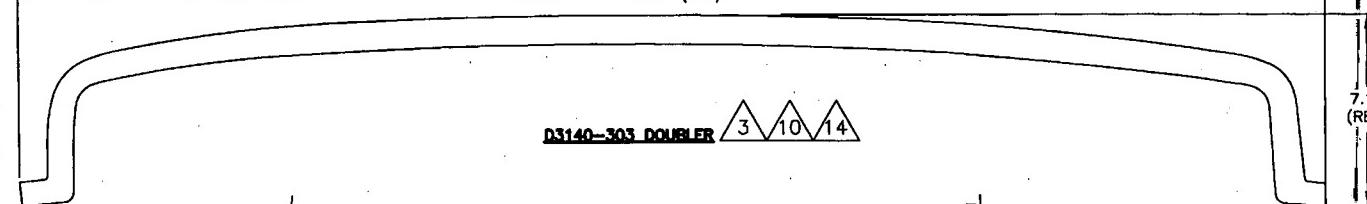
D3140-104 DOUBLER
D3140-103 OPPOSITE
4 14 D F

D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)

48.59 (REF)



D3140-301 DOUBLER 3 10 14



D3140-303 DOUBLER 3 10 14



D3140-85 ANGLE 6
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

7.25 (REF)

7.14 (REF)

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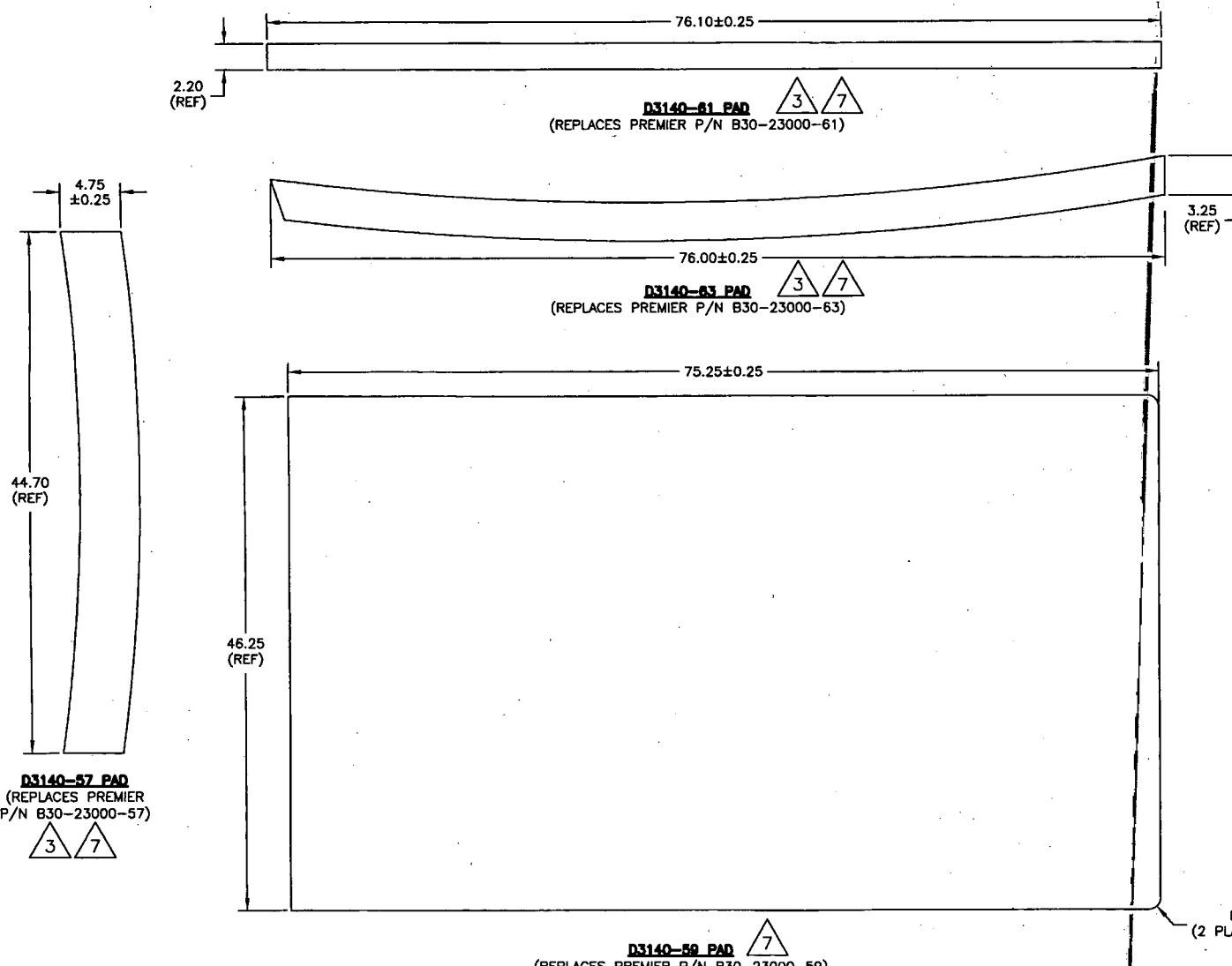
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DATE 06.10.06	TITLE DOOR	SCALE N/A	

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3.25 NO ← 5376?



D3140-241 DOUBLER △ 5 △ 14
(REPLACES PREMIER P/N B30-23000-241)

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		D3140	SHEET 7 OF 7
DATE	TITLE	SCALE	
06.10.06	DOOR	NTS	